

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003039**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

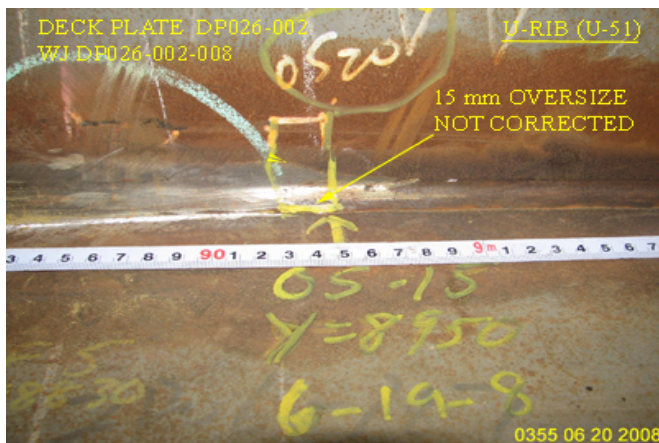
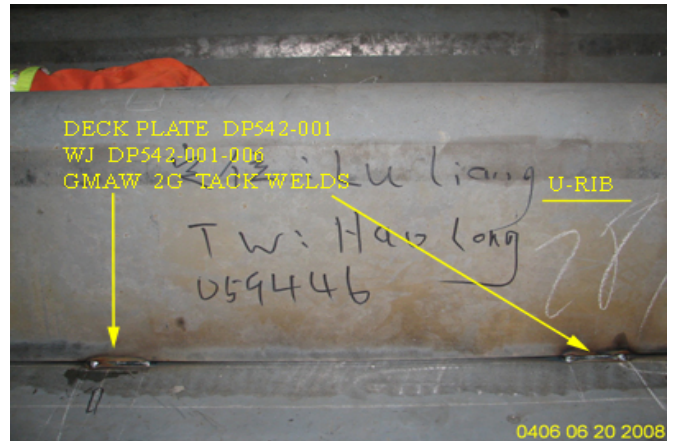
OBG Bay 1:

The QA Inspector randomly observed ZPMC welder Hao Long, utilizing the Gas Metal Arc Welding (GMAW) Process in the 2G (Horizontal Groove) Position, with ZPMC WPS WPS-B-T-2342-U2(U-Rib), to tack weld Closed Ribs to Deck Plate DP542-001 at Weld Joint (WJ) Numbers DP542-001-001 through DP542-001-006. The QA Inspector randomly observed ZPMC CWI Li Yanhua monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photographs provide additional detail.

The QA Inspector performed Visual Inspection of "In Process" repairs on the welds attaching U-Rib (u-51) to Deck Plate DP026-002 at WJ 008. VT Inspection Data was recorded on a separate spreadsheet. The attached photograph provides additional detail.

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Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer